

Work Order ID 67769

Wednesday, March 30, 2011 10:35:55 AM



Page 1

Item ID: D3278-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 3/30/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Handwritten signature

Date: 11-03-11 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3278 | Rev C | | | | | | | | |

100



Bandsaw

Jeaspa Bandsaw

SHEAR

Memo

Cut blank: 2.00" x 1.00" x 2.550" long

0.00

0.00

Handwritten signature and date 11/04/07

Handwritten 40 and checkmark

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1- Machine as per Folio FA405 and Dwg D3278-2- Deburr and Tumble Identify as D3278-2

0.00

0.00

Handwritten signature and date 11/04/07

Handwritten 40 and checkmark

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

Handwritten signature and date 11/04/07

Handwritten 40 and checkmark

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Item Name: Support

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B.A 11/04/11

40

0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

40

0

11/04/11

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M116964

START TIME:

8:10

OVEN TEMPERATURE:

FINISH TIME:

8:40

40

BR

11-4-12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Work Order ID 67769

Wednesday, March 30, 2011 10:35:55 AM



Page 3

Item ID: D3278-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 3/30/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 40.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

40.00 0 11/04/12

170

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

SB 11/04/12

40

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/13

MF 11-04-12

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NOTE: Date & initial all entries

Picklist Print

Wednesday, March 30, 2011 10:36:01 AM

Page 1

Work Order ID: 67769

Parent Item: D3278-2

Parent Item Name: Support



Start Date: 3/30/2011

Required Date: 4/4/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐
IPP B 07.09.06 Rev C dwg EC Verified by: JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B1.000X02.00 0 | | Purchased | | No | | 100 | f | 47.4400 | 0.2337 | 9.84 | | | |



6061-T6 Bar 1.00 x 2.00

| Location | Loc Qty | Loc Code |
|-----------|---------|----------|
| MAT004 | 47.44 | |
| 112567 | 22.6 | |
| 114415 15 | 4.58 | |
| 115045 | 5.6 | |
| 115952 25 | 8.33 | |
| 116623 | 6.33 | |

3.48
6.134 smk 11/04/01

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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|-----------------------|--------|----------------------|
| DART AEROSPACE LTD | | Work Order: 67769 |
| Description: Support | | Part Number: D3278-2 |
| Inspection Dwg: D3278 | Rev: C | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.098 | +0.005/-0.000 | Ø.098 | — | | Vern ML-7 | |
| 0.359 | +/-0.005 | .359 | — | | " | |
| 0.609 | +/-0.010 | .613 | — | | " | |
| 0.250 | +/-0.010 | .250 | — | | " | |
| 1.480 | +/-0.005 | 1.480 | — | | " | |
| R0.125 | +/-0.010 | R.125 | — | | Rad-gage | |
| 0.119 | +0.005/-0.004 | .120 | — | | Vern ML-7 | |
| 2.439 | +/-0.010 | 2.440 | — | | " | |
| 1.980 | +/-0.010 | 1.981 | — | | " | |
| R0.13 | +/-0.030 | R.125 | — | | Rad-gage | |
| Ø0.257 | +0.005/-0.000 | Ø.258 | — | | Vern ML-7 | |
| R0.375 | +/-0.010 | R.375 | — | | Rad-gage | |
| 0.875 | +/-0.010 | .875 | — | | Vern ML-7 | |
| 0.500 | +/-0.010 | .500 | — | | " | |
| R0.400 | +/-0.010 | R.400 | — | | " | |
| R1.00 | +/-0.030 | R1.000 | — | | Rad-gage | |
| 1.720 | +/-0.010 | 1.723 | — | | Vern ML-7 | |
| R0.125 | +/-0.010 | R.125 | — | | Rad-gage | |
| 0.125 | +/-0.010 | .126 | — | | Vern ML-7 | |

| |
|-------------------------|
| Measured by: <i>Amf</i> |
| Date: 11/04/07 |

| |
|------------------------|
| Audited by: <i>B.A</i> |
| Date: 11/04/11 |

| | |
|---------------------|-----|
| Prototype Approval: | N/A |
| Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------------------------|-----------------|-----------|
| A | 04.04.19 | New Issue P/O D3278-041 | KJ/JLM | |
| B | 05.06.08 | 0.359 was 0.365; 0.119 was 0.125 | KJ/JLM | |
| C | 07.09.26 | Dimensions updated per Dwg Rev. C | KJ/EC <i>AF</i> | <i>BE</i> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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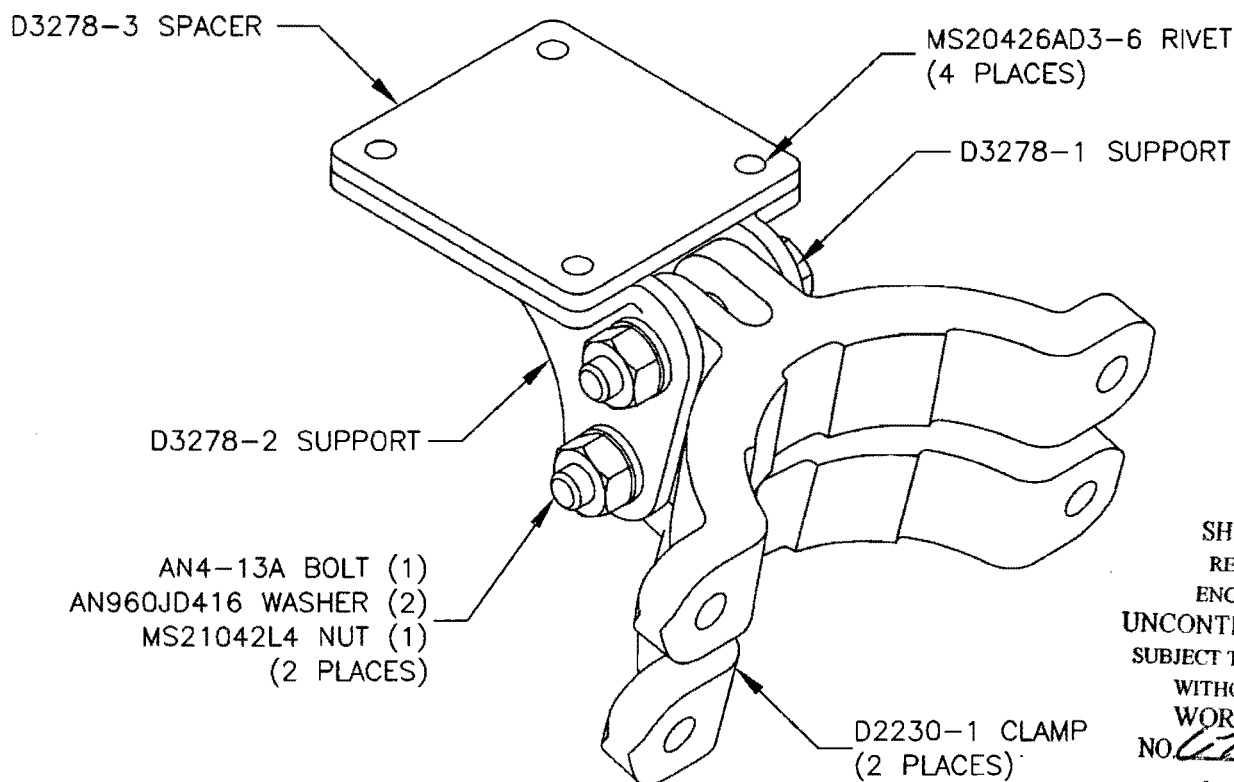
NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>97</i> | DRAWN BY <i>BC</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3278 | REV: C SHEET 1 OF 3 |
| DATE 07.07.24 | | TITLE SUPPORT ASSEMBLY | SCALE NTS |
| A | 04.03.03 | NEW ISSUE | |
| B | 05.03.31 | CHANGE DIM/TOL TO ENSURE FIT | |
| C | 07.07.24 | CHANGED RIVETS PER PAR #185 | |

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *67769*

PL11-03-30

| Qty | Part Number | Description |
|-----|--------------|------------------|
| X | D3278-041 | SUPPORT ASSEMBLY |
| 2 | D2230-1 | CLAMP |
| 1 | D3278-1 | SUPPORT |
| 1 | D3278-2 | SUPPORT |
| 1 | D3278-3 | SPACER |
| 2 | AN4-13A | BOLT |
| 4 | AN960JD416 | WASHER |
| 4 | MS20426AD3-6 | RIVET |
| 2 | MS21042L4 | NUT |

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

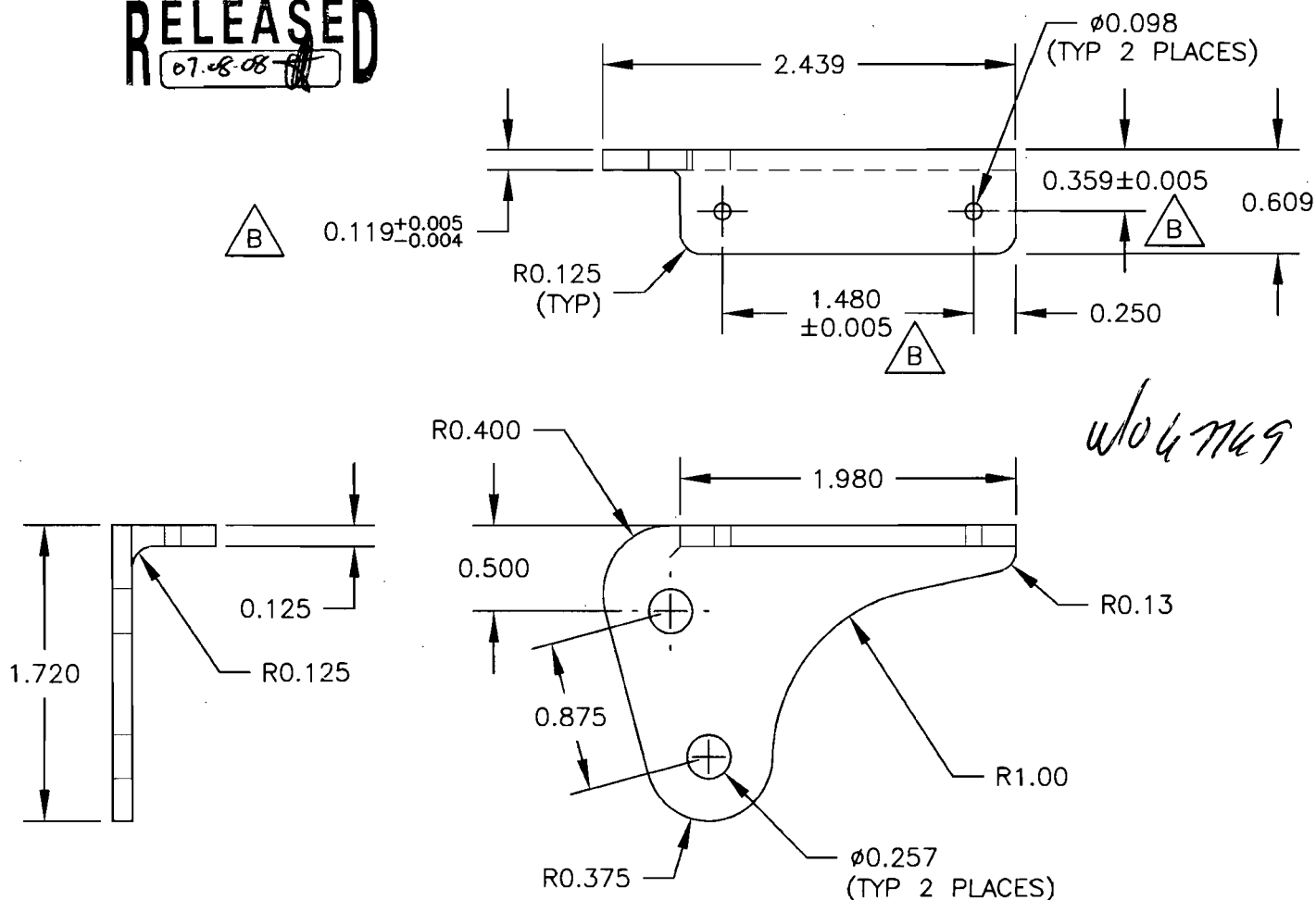
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NOTE: Date & initial all entries



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|---------------------|-----------------------|---|------------------------|
| DESIGN <i>GP</i> | DRAWN BY <i>BC</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>B</i> | APPROVED <i>H</i> | DRAWING NO. D3278 | REV. C SHEET 2 OF 3 |
| DATE 07.07.24 | | TITLE SUPPORT ASSEMBLY | SCALE 1:1 |

RELEASED
07-8-08



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRJT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

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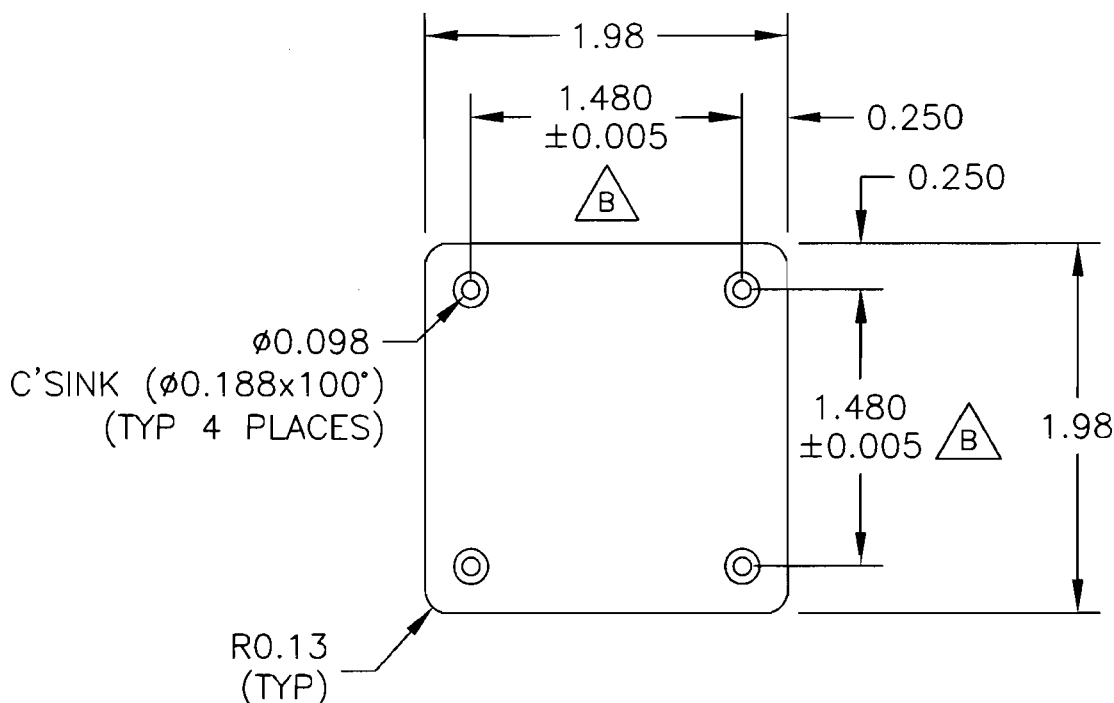
NOTE: Date & initial all entries



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|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>GP</i> | DRAWN BY <i>BC</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3278 | REV. C SHEET 3 OF 3 |
| DATE 07.07.24 | | TITLE SUPPORT ASSEMBLY | SCALE 1:1 |

RELEASED
07.08.08

wb 67769



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELIN-B0.125x2.000) OR
DELIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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